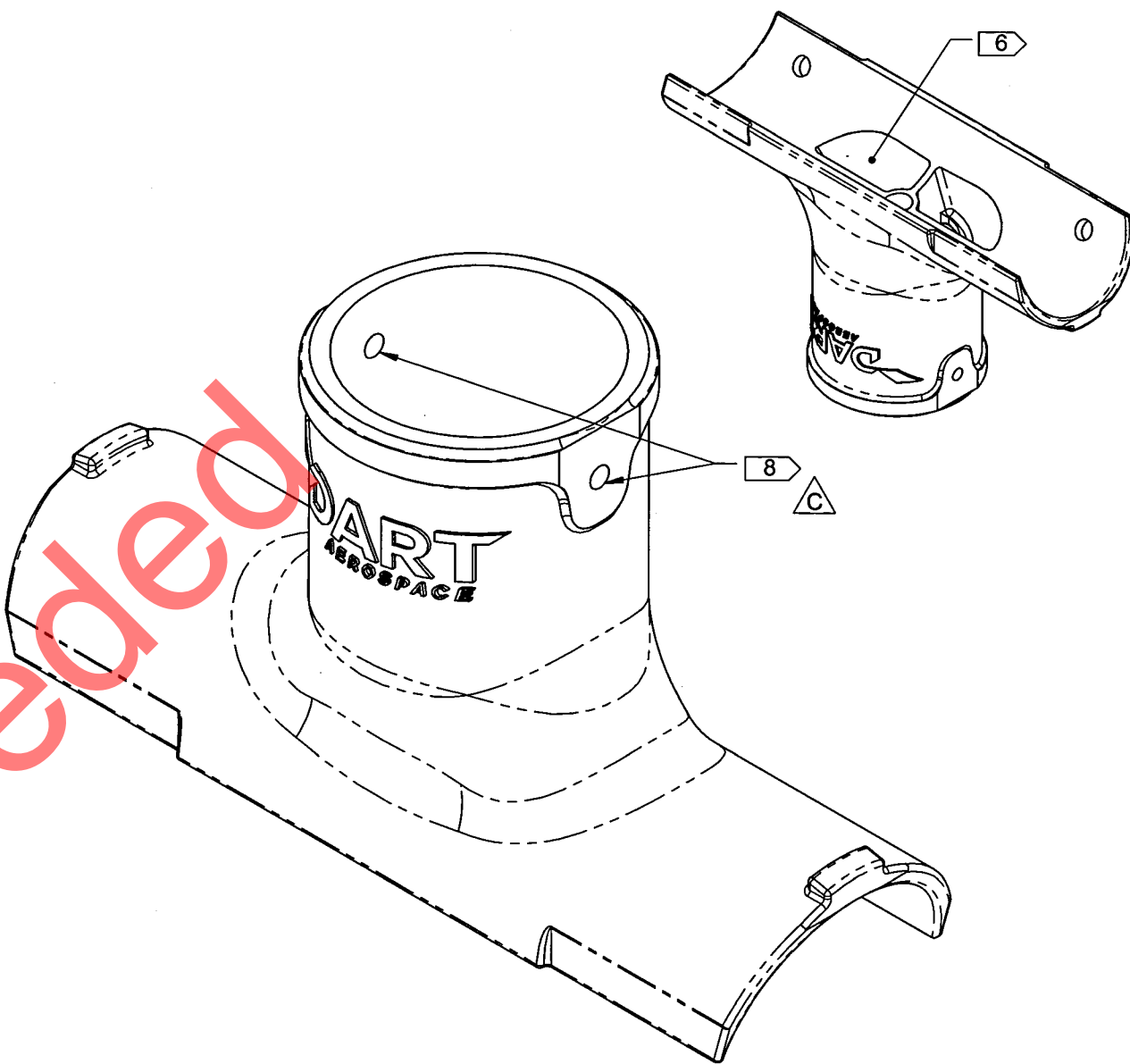


**D5415-1 MID HEIGHT SADDLE**



**D5415-3 STANDARD HEIGHT SADDLE**

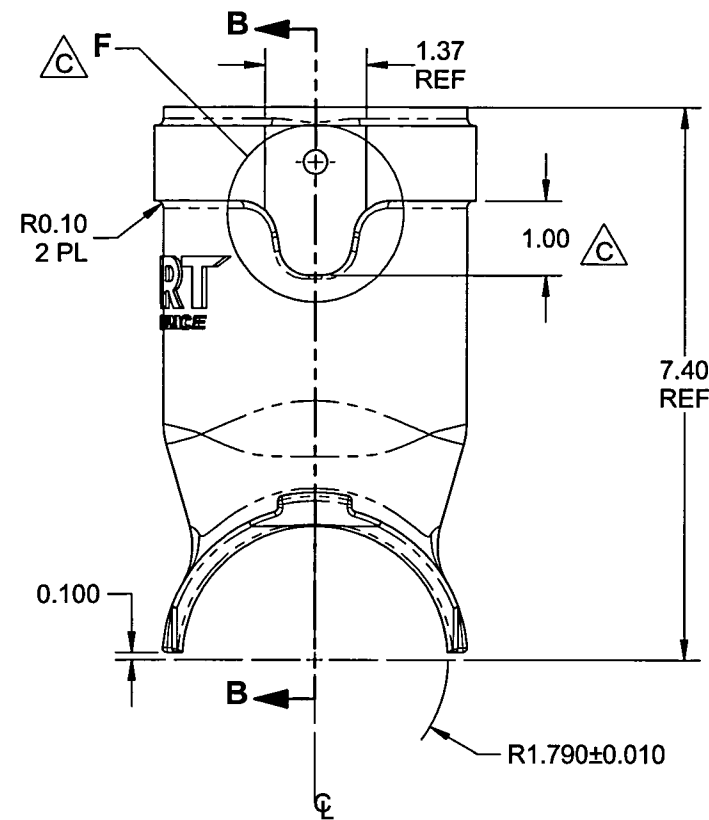
**NOTES:**

- 1) MATERIAL: MAKE FROM D5415-1C/-3C
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)  
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.4 (VIBRATING STYLUS) PRIOR TO FINISH  
DART P/N "D5415-1" OR "D5415-3" AND S/N PER QSI 044 6.1 (PAINT MARKER) AFTER FINISH  
LOCATE APPROX AS SHOWN
- 7) WEIGHT: D5415-1 is 3.72 LBS, D5415-3 is 3.42 LBS
- 8) MASK HOLES PRIOR TO PRIME AND PAINT

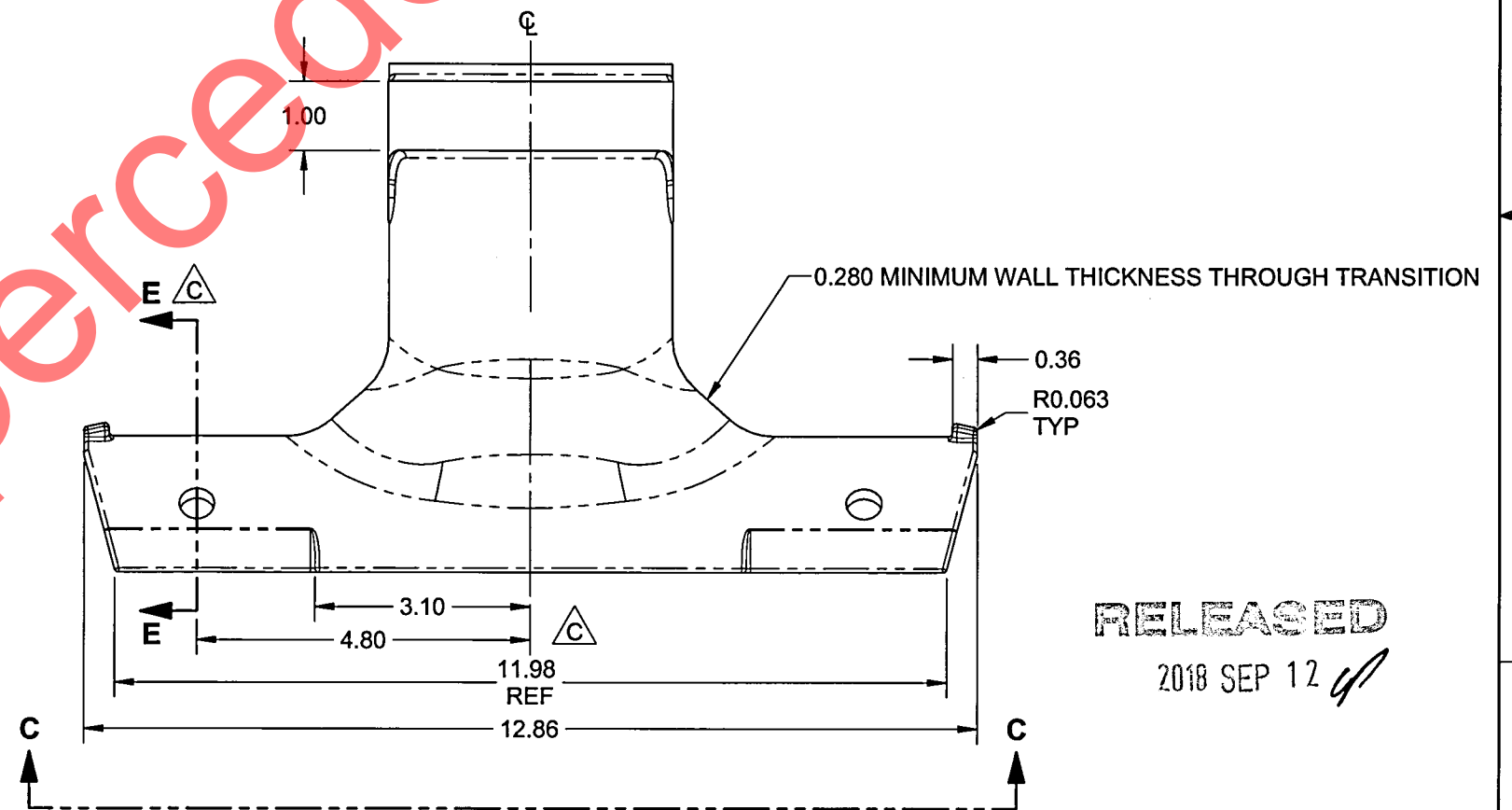
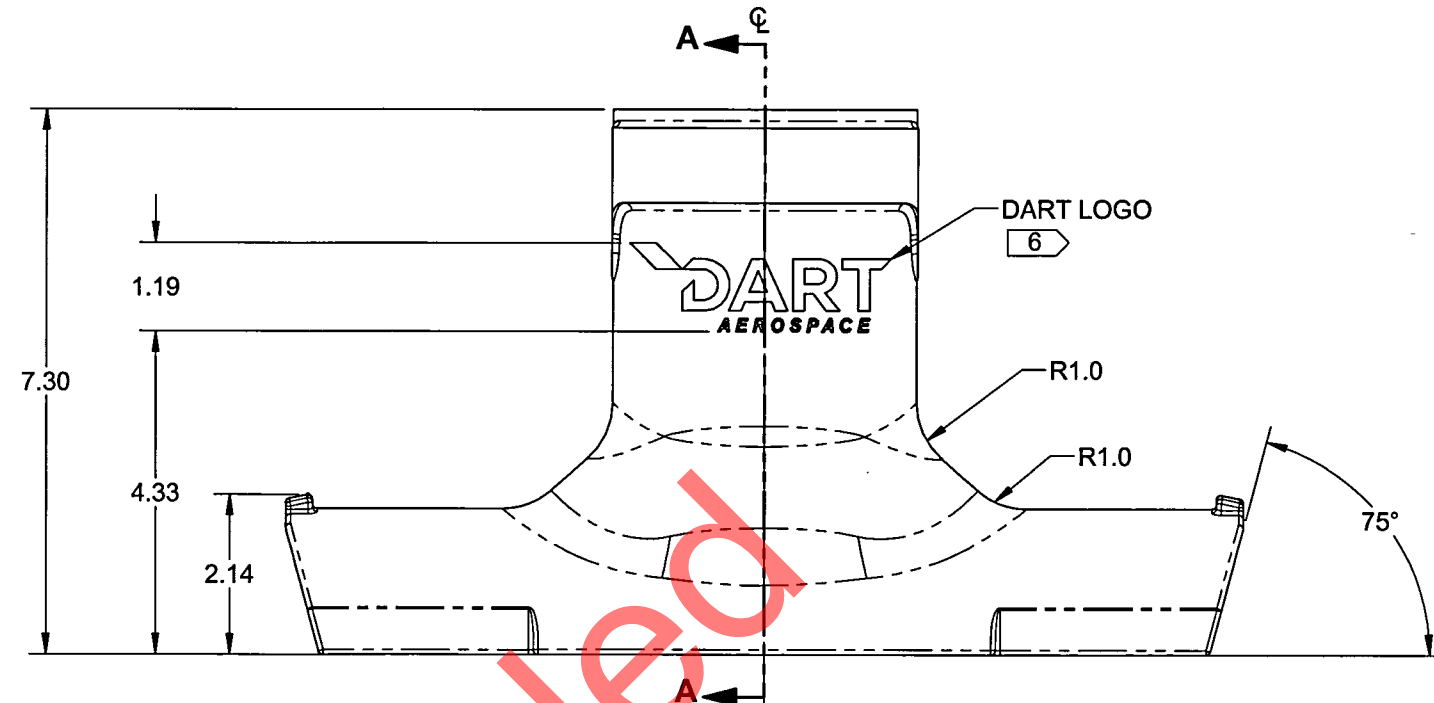
**RELEASED**  
2018 SEP 12  
ECN 18-001

APPROVED

C	REDESIGNED SADDLE ALIGNMENT METHOD, INCORPORATED SADDLE RADIUS WASHER (D5562-1) INTO CASTING. SHEET 1: ADDED NOTE 8. SHEET 4: 3.565 WAS 3.550, 2.715 WAS 2.700.	MW	18.08.29
B	ADDED -3 STANDARD HEIGHT SADDLE, REVISED NOTES, REMOVED CAST P/N FROM -1 SADDLE, Ø0.323 HOLE WAS Ø0.325, SECTION B-B AND D-D ±0.005 WAS ±0.010	ML	17.09.05
A	NEW ISSUE	ML	16.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5415	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
DATE	18.08.29	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D5415-1C MID HEIGHT SADDLE**



**NOTES:**

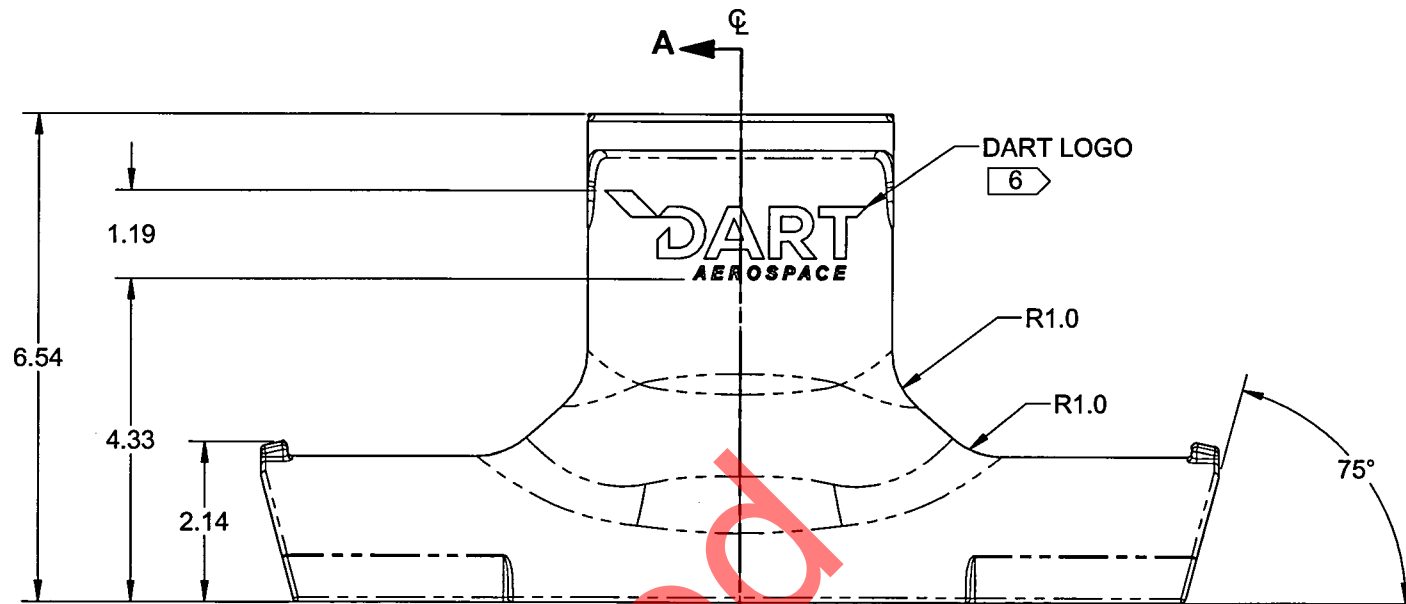
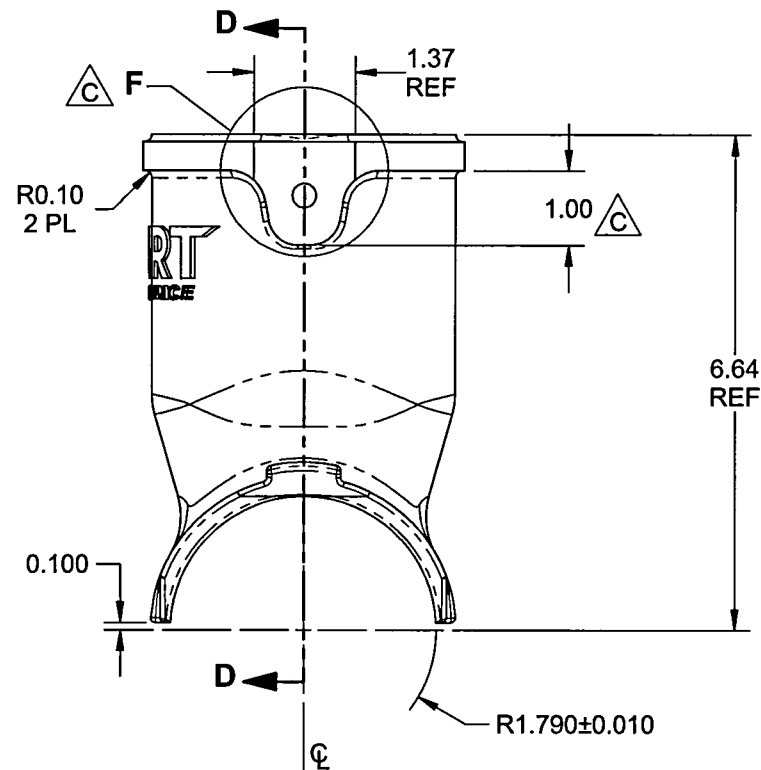
- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION  
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO CAST INTO PART AS SHOWN
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT
- 9) INSPECTION: EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175  
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER  
CAD FILE D5415-1-REV C.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS  
NOT SPECIFIED ON THIS DRAWING.

**RELEASED**

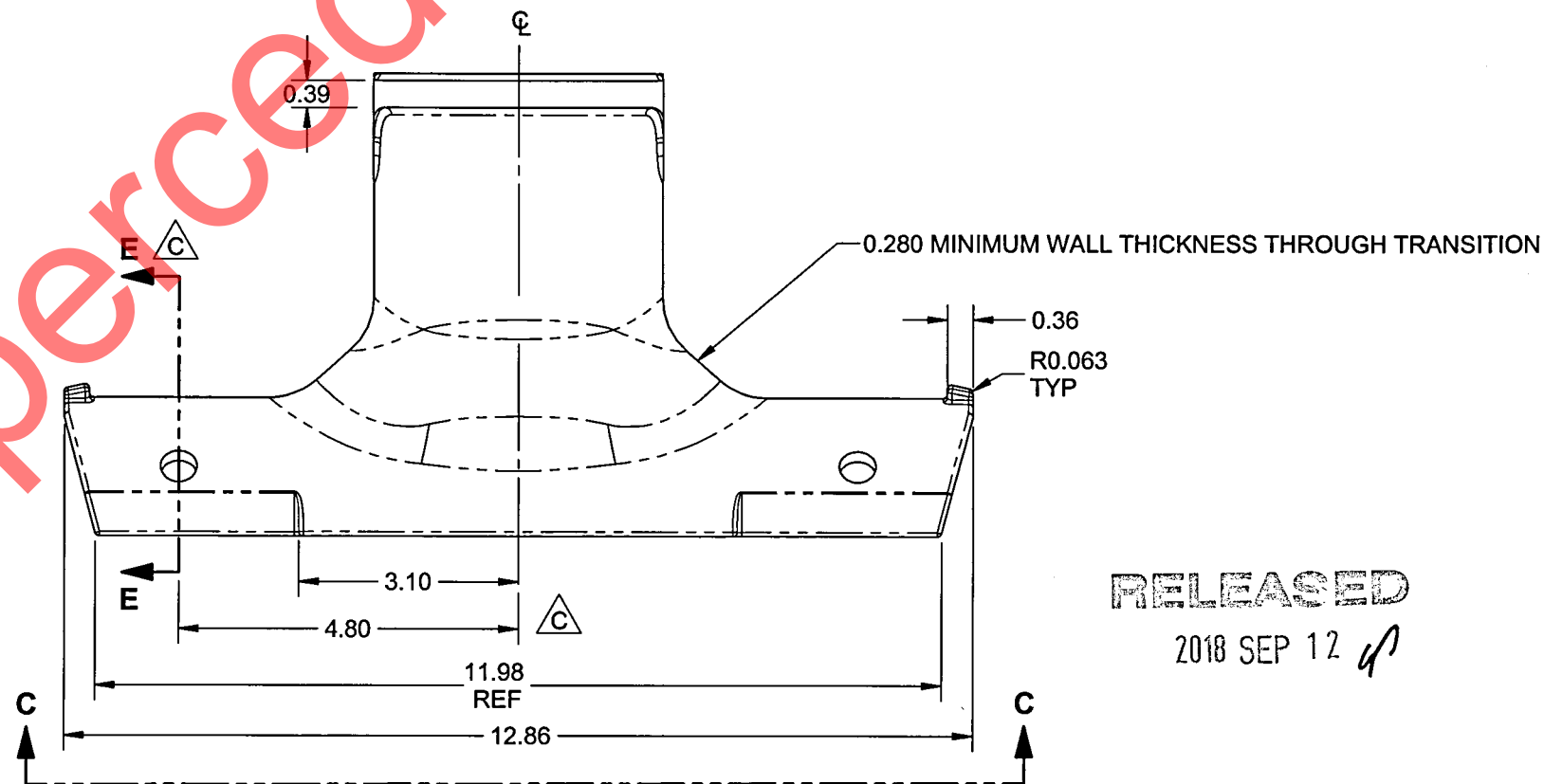
2018 SEP 12

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DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. C
MFG. APPR.	JFS	<b>D5415</b>	SHEET 2 OF 4
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**D5415-3C STANDARD HEIGHT SADDLE**



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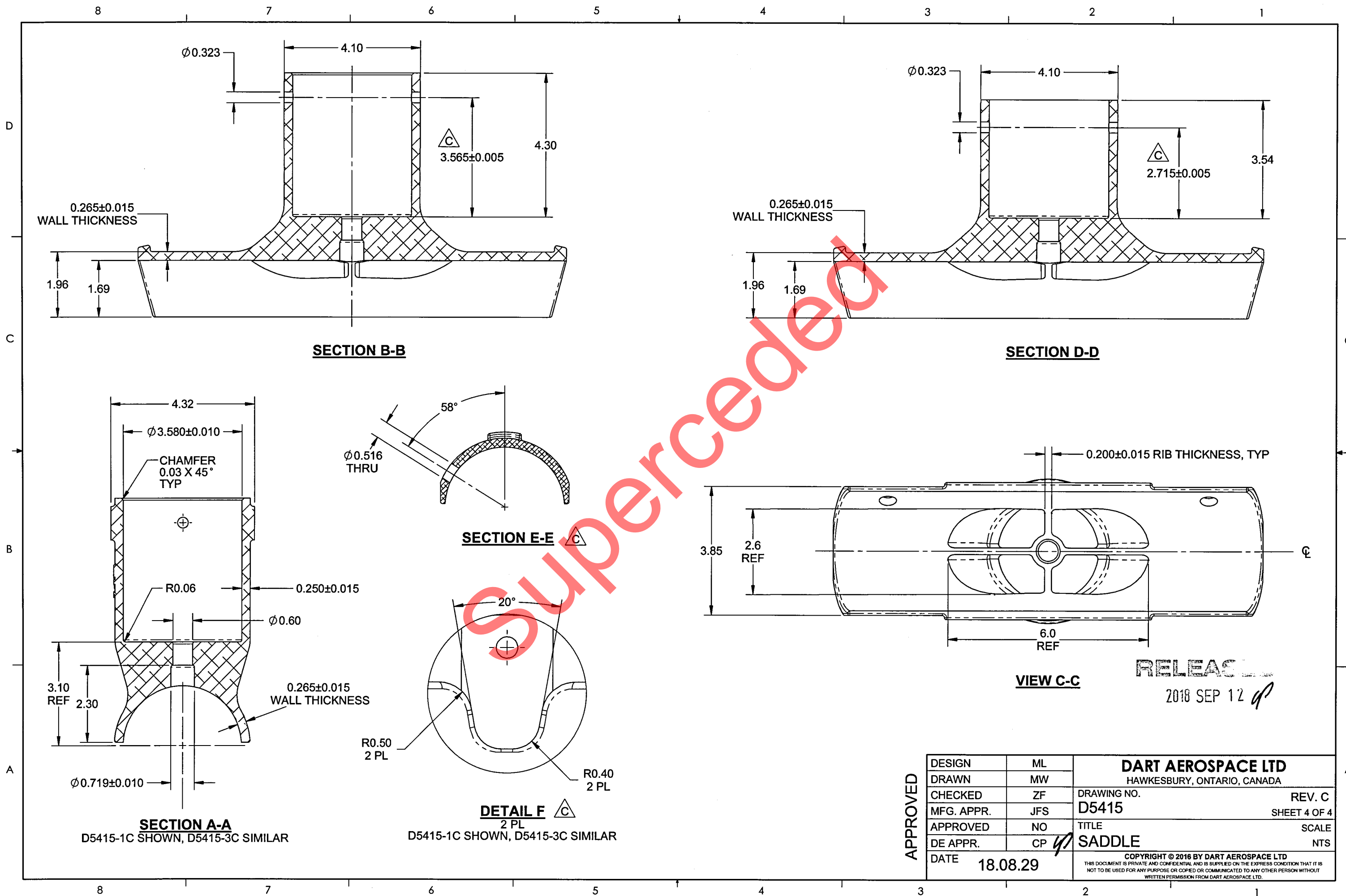
2018 SEP 12

**NOTES:**

- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION  
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO CAST INTO PART AS SHOWN
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT
- 9) INSPECTION: EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175  
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER  
CAD FILE D5415-3-REV\_C.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS  
NOT SPECIFIED ON THIS DRAWING.

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CHECKED	ZF	DRAWING NO.	REV. C
MFG. APPR.	JFS	<b>D5415</b>	SHEET 3 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>SADDLE</b>	NTS
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DRAWN	MW		
CHECKED	ZF	DRAWING NO. <b>D5415</b>	REV. C
MFG. APPR.	JFS	SHEET 4 OF 4	
APPROVED	NO	TITLE <b>SADDLE</b>	SCALE
DE APPR.	CP	NTS	
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